

Date: Wednesday, 7/5/2006 2:49:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 27816A		Part Number	: D2221	
Estimate Number	: 10189		Drawing Number	: D2221/D2235	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 7/5/2006 S.O. No. : N/A		Drawing Revision	: F/B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 7/30/2006	
Previous Run	: 27815A		Qty:	1 Um: Each	
Written By	: <i>See J comment below</i>				
Checked & Approved By	: <i>JL 06.07.05</i>				
Comment	: Est Rev.J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		4 D3166-1 RIB <i>321846</i>	<i>CPL 06.07.18</i>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2232-3 Hinge bracket <i>324527</i>	<i>CPL 06.07.18</i>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		4 D2325 Support Gusset <i>321582</i>	<i>CPL 06.07.18</i>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2327-3 Bushing <i>321051</i>	<i>CPL 06.07.18</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Appr. Mfg / Desig. Mgr

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/08/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/5/2006 2:49:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BASKET BASE ASSEMBLY (350)
Job Number: 27816A		Part Number: D2221
Job Number:		
Seq. #:	Machine Or Operation:	Description :
10.0	QC9/6	DDIMENSIONAL & WELDING INSPECTION 
Comment: DDIMENSIONAL & WELDING INSPECTION		 11/06/07/27 ①
11.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		SC 06/07/27 ① DC
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 11/06/07/01 ①
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Seal support gusset seam with white sikaflex-291 Batch: 11101193 Expiry date: 11/2006		m.f. 06/08/01
14.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		 11/06/08/03 ①
Job Completion		 CJ04108102

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>S</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

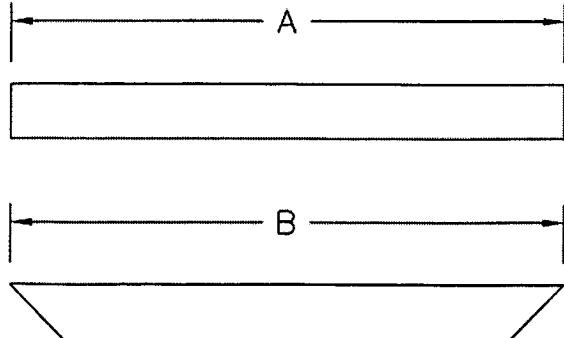
RELEASED

05.08.19 *SH*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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45 SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *27816A*

D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME

 D2221-1 (2) -
0.257 (TYP 5 PLACES)
(DRILL WHEN ASSEMBLING WITH
D2989-041/-043 LID ONLY)

6.50
(TYP. BOTH ENDS)

D2221-5 (2) —

D2221-3 (

D2232-3 (REF)
D3442-1 (REF)

1. *Leucosia* (Leucosia) *leucosia* (L.)

UNCG SUB

WOMEN
STRUCTURE
WITHIN
STRUCTURE
NETTING
325
SHOES
(REF)

COPY
RNT
SERV
DOLL
) AME
UT N
KORR
18.

HELLAS
G
D CO
NDME
TICE
DER
G.
05.08.19

TAPY

02221 BASKET BASE ASSEMBLY

2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART

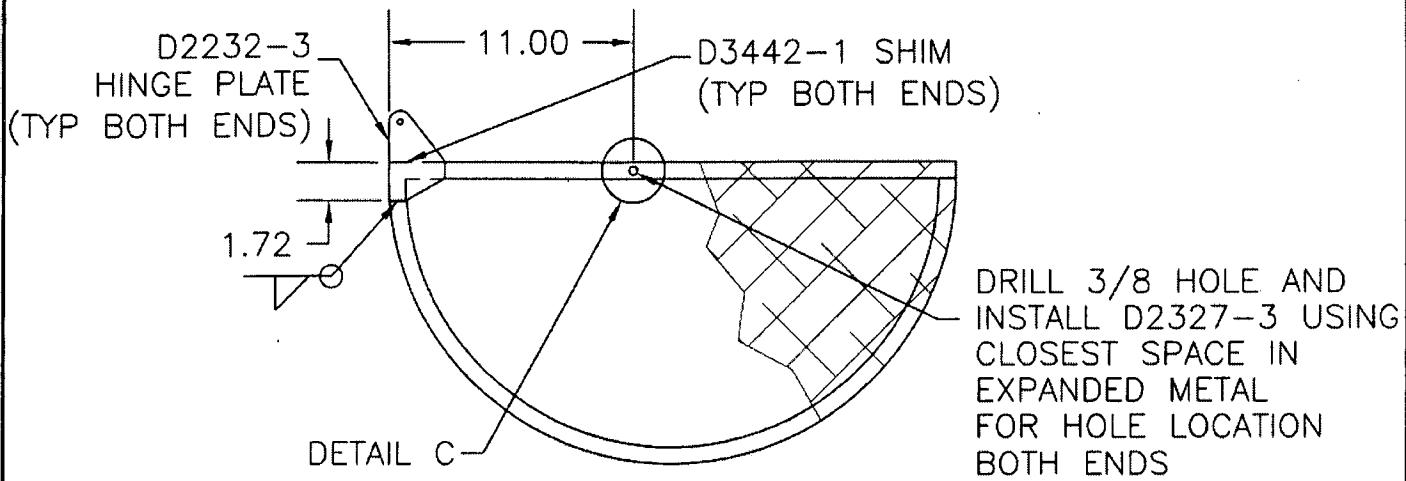
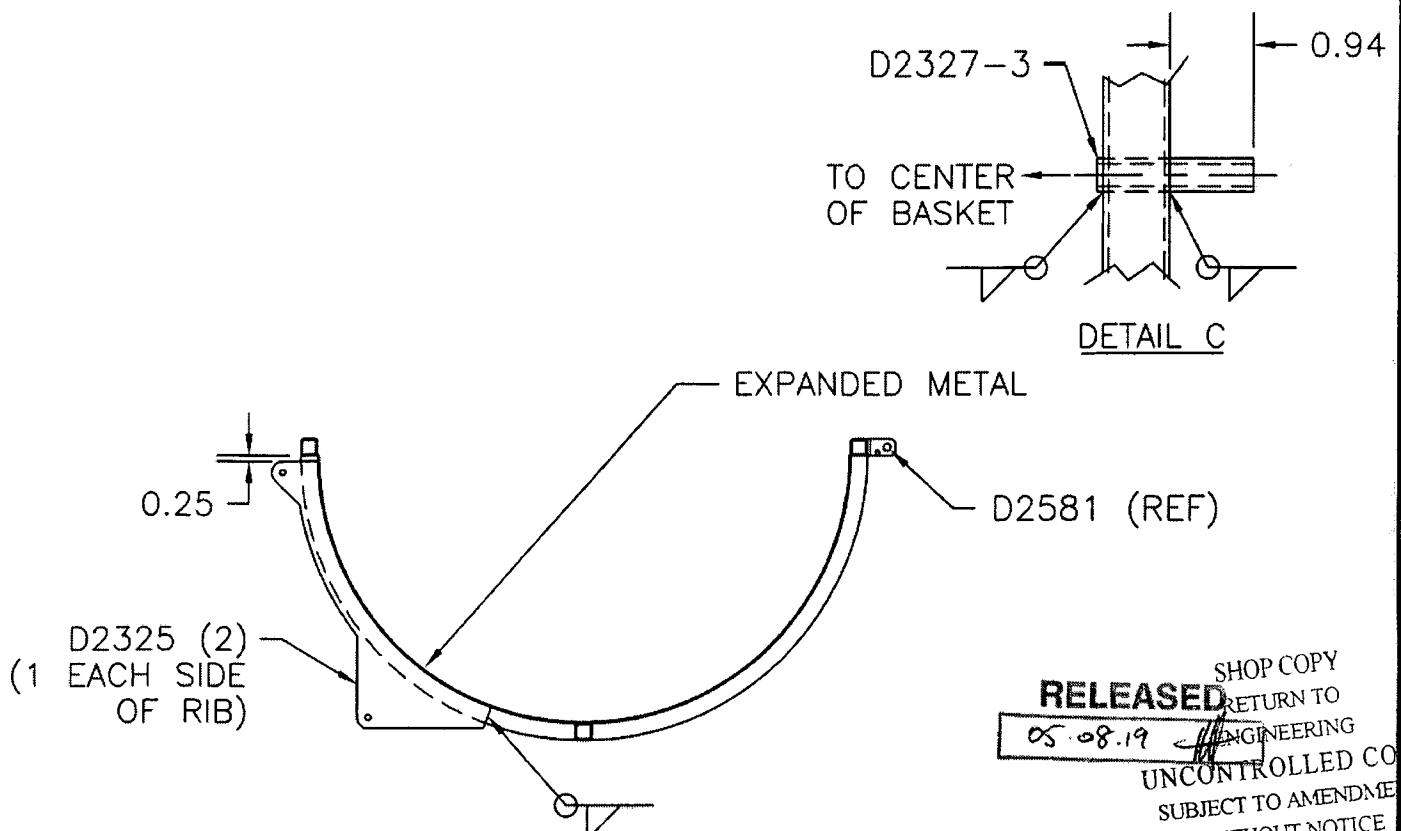
4) FINISH: POWDER COAT ENT

A technical drawing of a circular part. A vertical slot is located on the right side, extending from the center to the outer edge. A diagonal line is drawn from the top-left corner of the slot to the bottom-right corner. The text 'D2232-3' is positioned at the top left of the circle. To the left of the circle, there is a vertical line with the text 'D 1:1 (ENDS) 16F)' written vertically.

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD	
CHECKED		PH	HAWKESBURY, ONTARIO, CANADA	
DATE	05.06.07	APPROVED	DRAWING NO.	REV. F
			D2221	SHEET 2 OF 3
			TITLE	SCALE
			BASKET BASE ASSEMBLY (350)	1:20

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

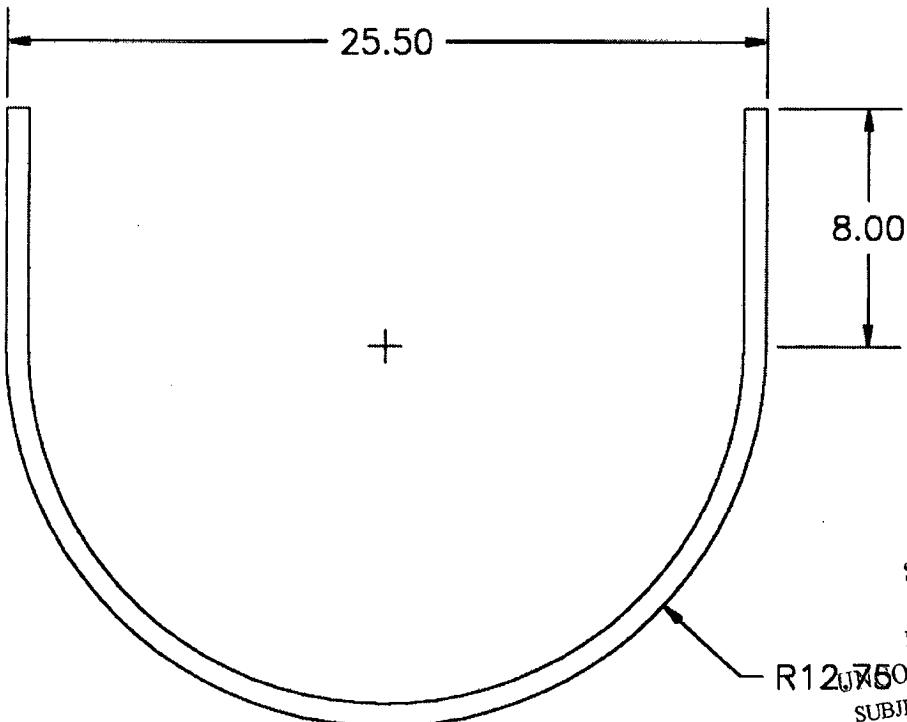
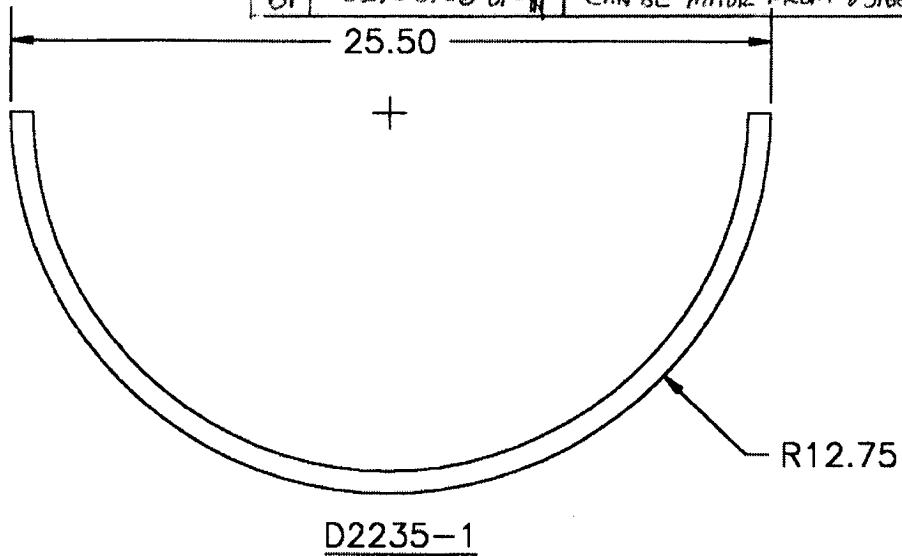
SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

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DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16	TITLE BASKET RIBS	REV. B SHEET 1 OF 1 SCALE

B1 02.08.06 *Off* CAN BE MADE FROM D3166-1RELEASED
R 960507CAN BE MADE FROM D3166-1 *Bi*

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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NO. *27876A*